

AMENDMENTS TO THE CLAIMS:

Please amend the claims as follows:

1. (Currently Amended) A roll apparatus provided at a continuous caster for transferring a cast piece to a predetermined location comprising:

at least three divided rolls arranged to align concentrically and in an axial direction thereof to constitute a roll forming a cast piece transfer path,

wherein at ~~least~~ least one end portion of at least one of the divided rolls is supported by a cylindrical roller bearing of a full roller type, said cylindrical roller bearing comprising an outer ring member having a cylindrical outer diameter surface.

2. (Currently Amended) The ~~roller roll~~ roll apparatus according to claim 1, ~~wherein the roll includes an upper forming roll and a lower forming roll each including at least three pieces of divided rolls having difference length in the axial direction, respectively,~~

wherein the upper forming roll and the lower forming roll are opposed to each other in a thickness direction of the cast piece, and

wherein an arrangement of the divided rolls of the upper forming roll and an arrangement of the divided rolls of the lower forming roll are made ~~difference~~ different from each other.

3. (Currently Amended) The ~~roller roll~~ roll apparatus according to claim 1, wherein ~~a plurality of the~~ at least three divided rolls are arranged in a direction of transferring the cast piece.

4. (Currently Amended) The ~~roller roll~~ roll apparatus according to claim 1, wherein end portions of all of the divided rolls are supported by cylindrical ~~roller roll~~ roll bearings, ~~of the said cylindrical roller bearings comprising full roller type bearings.~~

5. (Currently Amended) The ~~roller roll~~ roll apparatus according to claim 1, wherein each of the divided rolls is supported by an independent cylindrical ~~roll~~ roller bearing.

6. (Currently Amended) The ~~roller roll~~ roll apparatus according to claim 1, wherein the cylindrical roller bearing ~~includes~~ comprises:

an outer ring member with a flange supported by a roll supporting apparatus[,];
an inner ring member arranged on an inner side of the outer ring member in a diameter direction thereof concentrically therewith and externally fitted to an end portion of the divided roll[,]; and
a plurality of pieces of cylindrical rollers rollably arranged between the outer ring member and the inner ring member.

7. (New) The roll apparatus according to claim 1, wherein the cylindrical roller bearing comprises:

an outer ring member with a flange supported by a roll supporting apparatus.

8. (New) The roll apparatus according to claim 7, wherein the cylindrical roller bearing further comprises:

an inner ring member arranged on an inner side of the outer ring member in a diameter direction thereof concentrically therewith and externally fitted to an end portion of each of the divided rolls.

9. (New) The roll apparatus according to claim 8, wherein the cylindrical roller bearing further comprises:

a plurality of pieces of cylindrical rollers rollably arranged between the outer ring member and the inner ring member.

10. (New) A roll apparatus provided at a continuous caster for transferring a cast piece to a predetermined location, said apparatus comprising:

a roll comprising an upper forming roll and a lower forming roll each including at least three divided rollers, each of said divided rollers having a different length in the axial direction, wherein said divided rollers are arranged to align concentrically and in an axial direction, and

wherein at least one end portion of at least one of the divided rollers is supported by a cylindrical roller bearing.

11. (New) The roll apparatus according to claim 10, wherein said cylindrical roller bearing comprises a full roller type roller bearing.

12. (New) The roll apparatus according to claim 10, wherein each of said at least three divided rollers comprises at least a first roller, a second roller and a third roller.

13. (New) The roll apparatus according to claim 12, wherein the first roller comprises a shortest length and the third roller comprises a longest length.

14. (New) The roll apparatus according to claim 12, wherein an arrangement sequence of the first roller, the second roller and the third roller of the upper forming roll is opposite to an arrangement sequence of the first roller, the second roller and the third roller.

15. (New) The roll apparatus according to claim 10, wherein the cylindrical roller bearing comprises:

an outer ring member with a flange supported by a roll supporting apparatus.

16. (New) The roll apparatus according to claim 15, wherein the cylindrical roller bearing further comprises:

an inner ring member arranged on an inner side of the outer ring member in a diameter direction thereof concentrically therewith and externally fitted to an end portion of each of the divided rolls.

17. (New) The roll apparatus according to claim 16, wherein the cylindrical roller bearing further comprises:

a plurality of pieces of cylindrical rollers rollably arranged between the outer ring member and the inner ring member.

18. (New) The roller apparatus according to claim 16, wherein the inner ring member of each cylindrical roller bearing is inserted with an end portion of each of the first roller, the second roller and the third roller.

19. (New) The roll apparatus according to claim 10, further comprising:
a hydraulic cylinder apparatus for adjusting the distance between the upper forming roll and the lower forming roll.
20. (New) The roll apparatus according to claim 1, wherein each of said at least three divided rollers comprises a first roller, a second roller and a third roller,
wherein said first roller comprises a shortest length and the third roller comprises a longest length.
21. (New) The roll apparatus according to claim 10, wherein each of said at least three divided rollers comprises a first roller, a second roller and a third roller,
wherein said first roller comprises a shortest length and the third roller comprises a longest length.
22. (New) The roll apparatus according to claim 1, wherein each of said at least three divided rollers comprises a first roller, a second roller and a third roller,
wherein the lengths of the three pieces of rollers are the shortest in the first rollers and are lengthened in an order of the second rollers and the third rollers in an axial direction.
23. (New) The roll apparatus according to claim 10, wherein each of said at least three divided rollers comprises a first roller, a second roller and a third roller,
wherein the lengths of the three pieces of rollers are the shortest in the first rollers and are lengthened in an order of the second rollers and the third rollers in an axial direction.
24. (New) A roll apparatus provided at a continuous caster for transferring a cast piece to a predetermined location comprising:
at least three divided rolls arranged to align concentrically and in an axial direction thereof to constitute a roll forming a cast piece transfer path,
wherein at least one end portion of at least one of the divided rolls is supported by a cylindrical roller bearing of a full roller type,
wherein the cylindrical roller bearing comprises:

an outer ring member with a flange supported by a roll supporting apparatus;
an inner ring member arranged on an inner side of the outer ring member in a diameter direction thereof concentrically therewith and externally fitted to an end portion of the divided roll; and
a plurality of pieces of cylindrical rollers rollably arranged between the outer ring member and the inner ring member.

25. (New) A method of forming a roll apparatus provided at a continuous caster for transferring a cast piece to a predetermined location comprising:

arranging at least three divided rolls to align concentrically and in an axial direction thereof to constitute a roll forming a cast piece transfer path, and

supporting at least one end portion of at least one of the divided rolls by a cylindrical roller bearing of a full roller type,

wherein the roll comprises an upper forming roll and a lower forming roll, each including at least three pieces of divided rolls having different lengths in the axial direction.

26. (New) The roll apparatus according to claim 1, wherein said outer diameter surface is linear in an axial direction.

27. (New) A roll apparatus provided at a continuous caster for transferring a cast piece to a predetermined location comprising:

at least three divided rolls arranged to align concentrically and in an axial direction thereof to constitute a roll forming a cast piece transfer path,

wherein at least one end portion of at least one of the divided rolls is supported by a cylindrical roller bearing of a full roller type,

wherein the cylindrical roller bearing comprises:

an outer ring member with a flange supported by a roll supporting apparatus;

an inner ring member arranged on an inner side of the outer ring member in a diameter direction thereof concentrically therewith and externally fitted to an end portion of the divided roll; and

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a plurality of pieces of cylindrical rollers rollably arranged between the outer ring member and the inner ring member.